

Work Order ID 141877

Thursday, February 18, 2016 1:29:37 PM

141877

Page 1

Item ID: D4365-3

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bar

Start Date: 2/18/2016 Start Qty: 16.00

16

Cust Item ID:

Required Date: 2/25/2016 Req'd Qty: 16.00

16

Customer:

Reference:

Approvals: Process Plan: *MLJ*

Date: FEB 18 2016

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
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D4365	A
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100

0.00

100

Cold Saw

Memo

0.00

Hyd Mech

Cut blanks at 66.0"

EXTRA MAT'L WILL BE TRIM OF AT ASSY

110

0.00

110

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Mill as per folio F___ & dwg,

FOLIO REV: *AA*

DWG REV: *BA*

2-Deburr as required

16

SL 16-2-23

16

SL 16-2-24

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Page 2

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Cust Item ID:

Required Date: 2/25/2016 Req'd Qty: 16.00

16

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

16 0 16-2-24

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

16 0 DAS
14
9-39
16/02/25

140

Identify as per dwg & Stock Location: W/401

0.00

140

Packaging

Memo

0.00

Packaging

16 0 16-2-25

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Cust Item ID:

Required Date: 2/25/2016 Req'd Qty: 16.00

16

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	--------------	---------------	---------------	------------------	----------------

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.00

Quality Control

MCS FEB 25 2016

MCS FEB 25 2016

Picklist Print

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Work Order ID: 141877

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Parent Item: D4365-3

D4365-3

Parent Item Name: Bar

Start Date: 2/18/2016

Required Date: 2/25/2016

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP REV:A 11.04.12 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.250x0.500		Purchased	No				f	1,295.210		90.52632			

M304B0 250x0 500

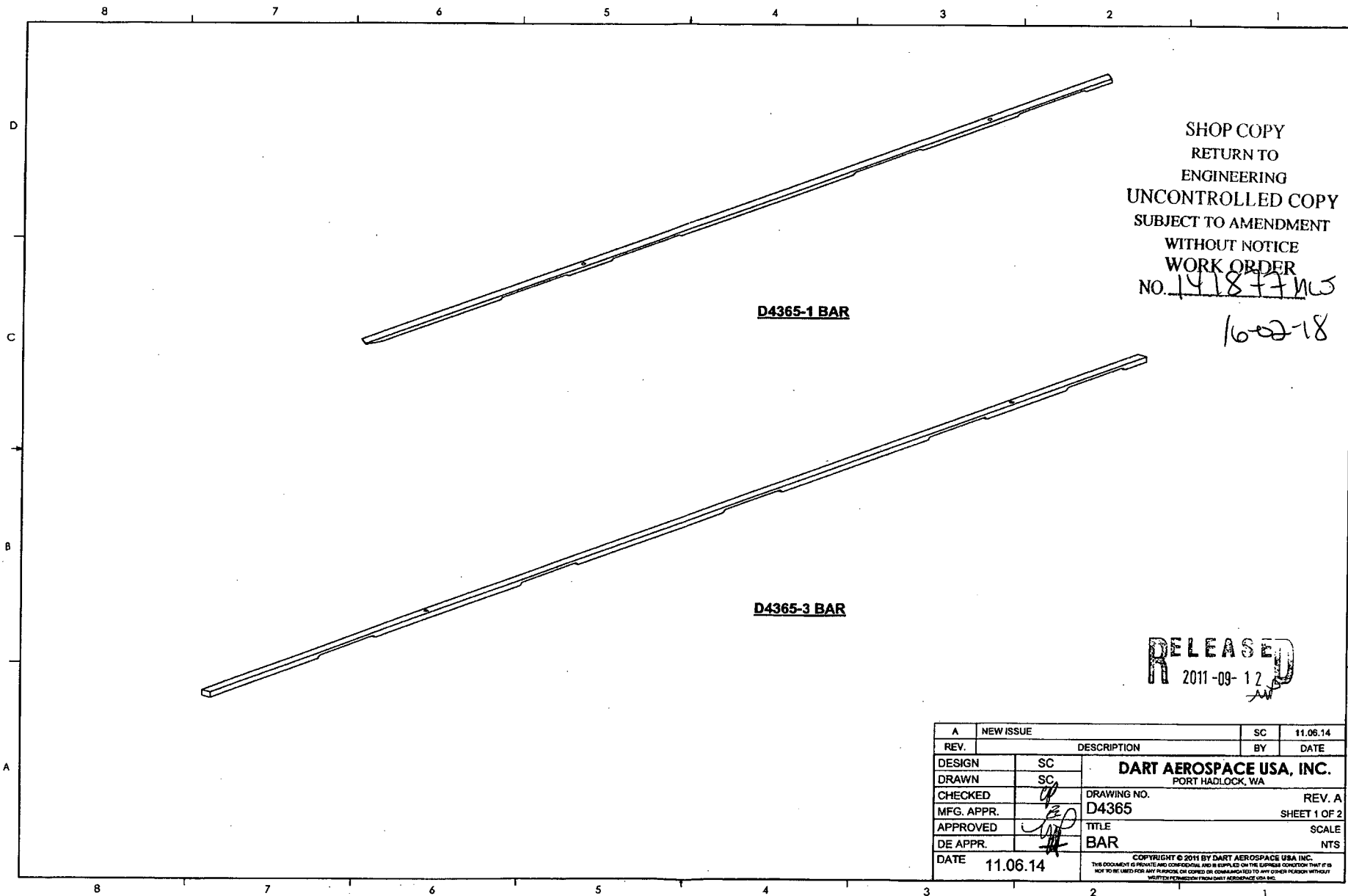
**

304 BAR .250 x .500

SL 162-23

Location	Loc Qty	Loc Code
MAT	258.909	
133276	10.979	
m133175	7.93	
m134172	240	
MAT009	532.3013	
m129366	18.967	
m131748	20.949	
m132332	48.5333	
m133121	12	
m133417	132.685	
m133526	23.167	
m133596	96	
m134099 ^{x2}	180	
WA002	504	
m133923	504	

x 96.0



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 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 141877NW

1602-18

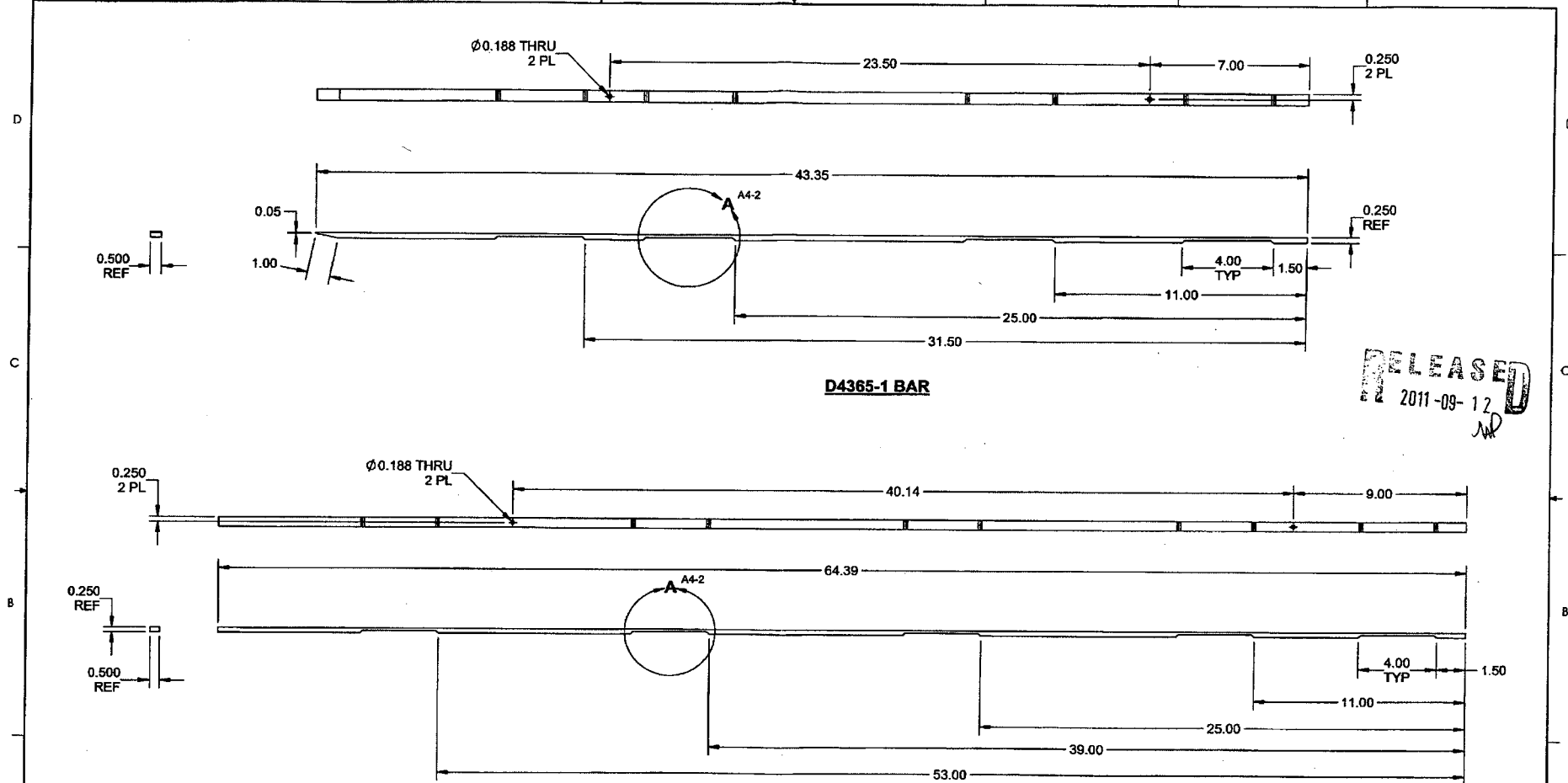
D4365-1 BAR

D4365-3 BAR

RELEASED
 2011-09-12
 AM

A		NEW ISSUE		SC	11.06.14
REV.		DESCRIPTION		BY	DATE
DESIGN	SC	DART AEROSPACE USA, INC. PORT HADLOCK, WA		REV. A	
DRAWN	SC			SHEET 1 OF 2	
CHECKED	<i>[Signature]</i>	DRAWING NO.	D4365		
MFG. APPR.	<i>[Signature]</i>	TITLE	BAR		
APPROVED	<i>[Signature]</i>	SCALE	NTS		
DE APPR.	<i>[Signature]</i>	DATE 11.06.14			
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8 7 6 5 4 3 2 1

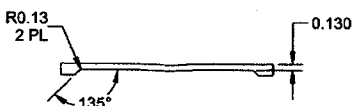


RELEASED
2011-09-12
MD

D4365-1 BAR

D4365-3 BAR

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR. 0.250 THICK X 0.500 WIDE
PER ASTM A276 OR ASTM A240
REF. DART SPEC. M30480.250X00.500
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: D4365-1 = 1.28 lbs
D4365-3 = 1.98 lbs



DETAIL A
TYP B5-2
D5-2

DESIGN	SC	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	SC		
CHECKED	UP	DRAWING NO. D4365	REV. A
MFG. APPR.	BP		SHEET 2 OF 2
APPROVED	MD	TITLE BAR	SCALE NTS
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DATE	11.06.14		

8 7 6 5 4 3 2 1